



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3389-1
Job Sheet 184435



Part No: D3389-1

Job Qty: 5 ea

Part Name: Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-02-08 As per Rev C JLM IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Skidtubes-1		DD
100	Skidtubes	5 pcs	11/2/18	11/2/18	0.00	3.03	Skidtubes-3		TF
110	QC	5 pcs	11/2/18	11/2/18	0.00	0.00	QC5		BF
120	HandFinish	5 pcs	11/2/18	11/2/18	0.00	1.08	HandFinish1		DR 18/10/11
130	QC	5 pcs	11/2/18	11/2/18	0.00	0.00	QC7-2		MAC
140	Packaging	5 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1		DD
150	QC21-SA	5 Ea	11/2/18	11/2/18	0.00	0.00	QC21		21

Part Op 100 - 1- Pick D2500-3-100 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut
Descriptions: line. 4- Cut to finished length 5- Open holes to finished size as per dwg D3389 6- Debur

140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100	Ext'n -I' Beam Web 4"	5 Ea (1 ea)	90-Start up Operation	5083738

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-3-100	5	68	0

Part Specifications

Specifications could not be found.

Plex 10/9/18 2:54 PM Dart.lajeunesse.marie

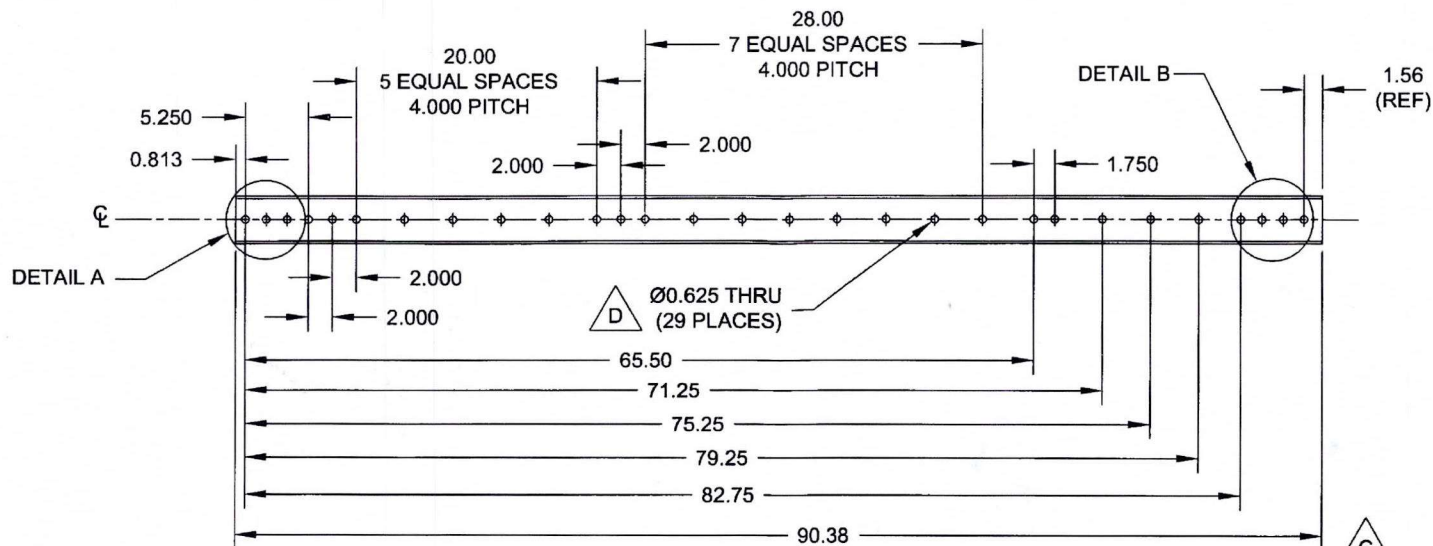
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

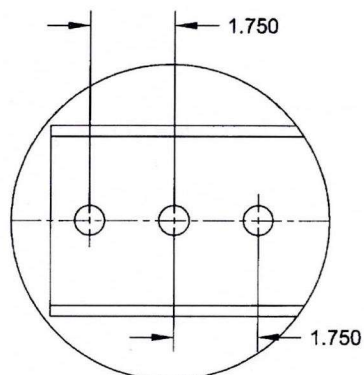
QA Closed: _____ Date: _____

Work Order update only ☐

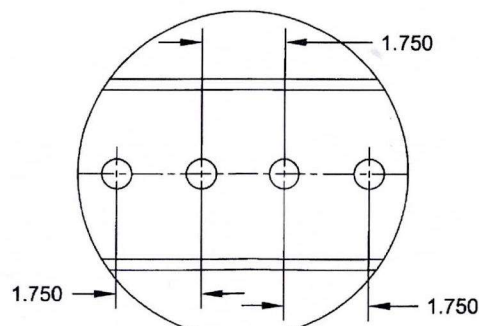
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																															
Description Work Order Deviation			Disposition																																
			Completed By																																
			Lead hand / Supervisor Approval Verification																																
			QC / QA Coordinator Approval																																
1700 S. Green Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Contact: S117267 Part: D3369 - 1 Job No: 184435 Serial No/Batch: S117267 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/11/18 FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Environment</td> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Design</td> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Doc/Data</td> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Equip/Tooling</td> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Handling/Pre</td> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Material</td> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Internal Transport</td> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Tribal Knowledge</td> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ LOA</td> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Substation</td> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>						☐ Environment	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Design	☐ Folio/Program	☐ Outside Dimensions	☐ Doc/Data	☐ Grain	☐ Over/Under tolerance	☐ Equip/Tooling	☐ Weld	☐ Part Incorrect	☐ Handling/Pre	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Material	☐ Out of Sequence	☐ Part Moved	☐ Internal Transport	☐ Off-set	☐ Drawing	☐ Tribal Knowledge	☐ Mislabeled	☐ Finish	☐ LOA	☐ Fit/Function	☐ Misread	☐ Substation	☐ Misaligned/off center	☐ Turning Sequence
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Past Expiry Date ☐ Manufacturing Process _____ Misidentified ☐ Past Due ☐ OTHER : _____																																			



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.09

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 WORK ORDER
 NO. 184435
 187025

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC
 PORT HADLOCK, WA
 DRAWING NO. D3389
 TITLE 412 WEB
 REV. D
 SHEET 1 OF 1
 SCALE 1:10
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